

Work Order ID 62665-1

Thursday, October 07, 2010 8:06:50 AM

Page 1

Item ID: D2230-1

Accept

Revision ID:

Item Name: Lug

Start Date: 10/6/2010 Start Qty: 100.00

Required Date: 10/15/2010 Req'd Qty: 100.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2230

Rev F

100

0.00



Bandsaw

BAND SAW

Memo

0.00

Jeaspa Bandsaw

Cut D2423 extrusion to 0.82"

Batch:

110



HAAS 1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FA927

DWG REV:

FOLIO REV:

(Check for crack while loading into the machine.)

2- deburr rough edges

CL 10/10/07 (100)

Issue P.O. 12709  
Machine per drawing D2230 Rev F.G

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

# Work Order ID 62665

Thursday, October 07, 2010 8:06:50 AM



Page 2

Item ID: D2230-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 10/6/2010 Start Qty: 100.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120



QC

Quality Control

QC2 Inspect parts off machine FAI/FAIB

0.00

*Receive + Inspect for transit damage*

Memo

0.00

*Ensure (S) C attached*

*Perkins (SC)*

130



QC

Quality Control

QC8 Inspect parts - second check

0.00

*QC8*

Memo

0.00

*S 10/10/25*

*counters*  
*x50*

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

*BL 10-10-26*

*50*



W/O:		WORK ORDER CHANGES					
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# Work Order ID 62665

Thursday, October 07, 2010 8:06:50 AM



Page 3

Item ID:	D2230-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Lug					
Start Date:	10/6/2010	Start Qty:	100.00		Cust Item ID:	
Required Date:	10/15/2010	Req'd Qty:	100.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 => M 10/10/26 0.00				(50)	4		
160  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M115291 Memo START TIME: 12:00 OVEN TEMPERATURE: 300° FINISH TIME: 12:30	0.00 BR 10-10-26 0.00				(50)			
170  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 => M 10/10/26 0.00				(1500)	8		

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

**Work Order ID 62665**

Page 4

Thursday, October 07, 2010 8:06:50 AM

Item ID: D2230-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 10/6/2010 Start Qty: 100.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 100.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

Identify as per dwg & Stock Location: 43

0.00



Packaging

Memo

0.00

Packaging

*Per 10/10/27* (50)

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/10/27*  
*CL 10/10/27*



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**NOTE:** Date & initial all entries



# Picklist Print

Thursday, October 07, 2010 8:06:54 AM

Page 1

Work Order ID: 62665

Parent Item: D2230-1

Parent Item Name: Lug




Start Date: 10/6/2010

Required Date: 10/15/2010

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP ☐ D00.11.01 ☐ Added inspection level 8, and removed P/O for powder coat ☐ EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423  Lug Extrusion		Manufactured	No			110	f	342.8550	0.0683	7.189474			

Location

Loc Qty

Loc Code

MAT06

342.8549795

43722

180

45800

162.854979

7.189474 10/10/27

D2230-1P x100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

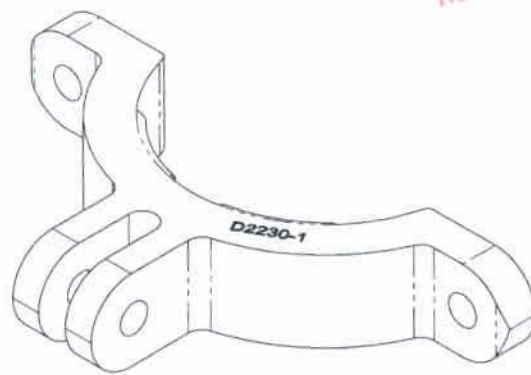
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

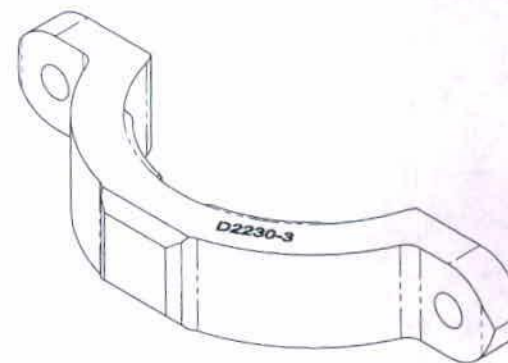
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SHOPLIFT  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO REVISIONS  
WITHIN SUPPLIER  
WORK ORDER  
NO. 42465  
B/10-10-07



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

RELEASED  
09/01/16



**NOTES:**

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs  
-3: 0.14 lbs

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION	AJS	09.01.16
F	RE-DESIGN: R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2230	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MOUNTING LUG	NTS
DATE	09.01.16	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



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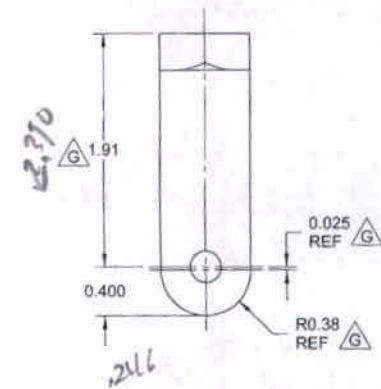
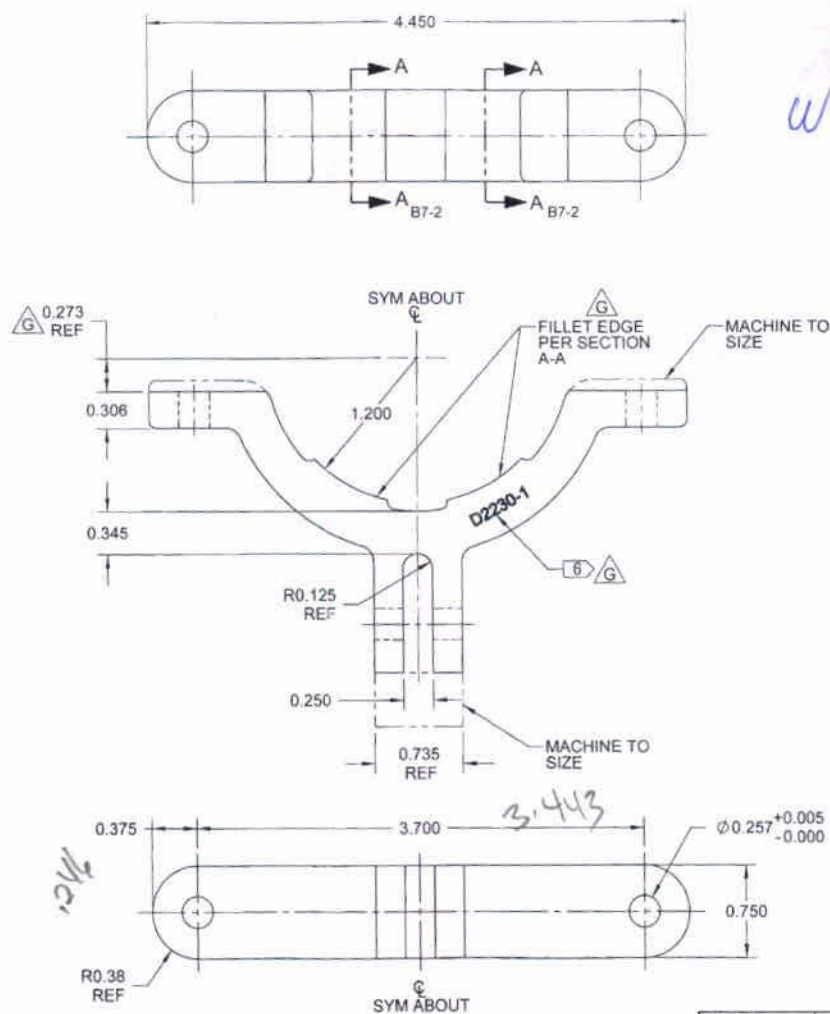
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**NOTE:** Date & initial all entries

**SECTION A-A** D4-2  
SCALE 2X



R0.06 MIN - R0.10 MAX  
2 PL



**D2230-1 MOUNTING LUG**

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO	REV. C
MFG. APPR.		D2230	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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**RELEASED**  
09/06/25/16

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## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
100	D2230-3	Mounting Lug	12709
80	D2230-3	Mounting Lug	12709
50	D2230-1	Mounting Lug	12709

*Signature* 10/10/25

MATERIAL: Supplied by DART D2324 45800

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

*Signature*  
Shigi Walz

Vankleek Hill, October 22, 2010